

Date: Thursday, 2/22/2007 2:57:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 30813C		
Estimate Number	: 10354		
P.O. Number	: <i>N/A</i>	Part Number	: D2322
This Issue	: 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 29922C	Material	: <i>N/A</i>
Written By	:	Due Date	: 2/6/2007 Qty: 10 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.02.23		
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.1315 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2322  
 Batch: *M102448*

SAD 07/02/28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2322  
 Dwg Rev: *C*  
 Prog Rev: *C*

SAD 07/02/28

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/28

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/02/28

5.0	BRAKE NC	NC BRAKE
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

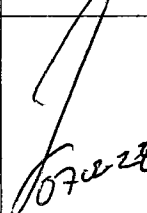
Comment: NC BRAKE  
 Form as per Dwg D2322

SAD 07/03/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PD Date: 07/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/28	2.0	Wrong Grain direction (1 part)		Scrap & destroy "replace"	SAN 07/01/28	 07/02/28		

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 30813C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07/03/13

10

Comment: INSPECT WORK TO CURRENT STEP

~~07/03/13~~

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l

07/03/14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/15

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN		DRAWN BY	DART AEROSPACE LTD	
Bw		CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	DRAWING NO.	REV. C
DATE		TITLE		SHEET 1 OF 1
98.09.29		STEP SPACER		SCALE
		NEW ISSUE		1:2
A		94.10.14		
C		98.09.29		
		4.428 WAS 4.460, 0.040 WAS 0.032		
		CHANGES PER NCR 001		

RELEASED  
98.10.08 DS

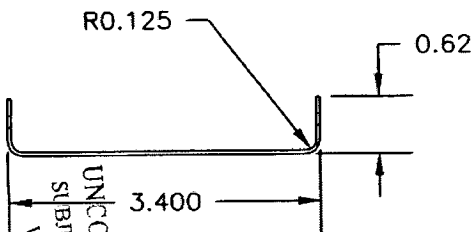
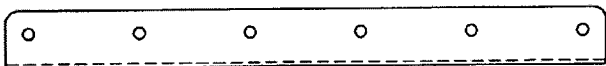
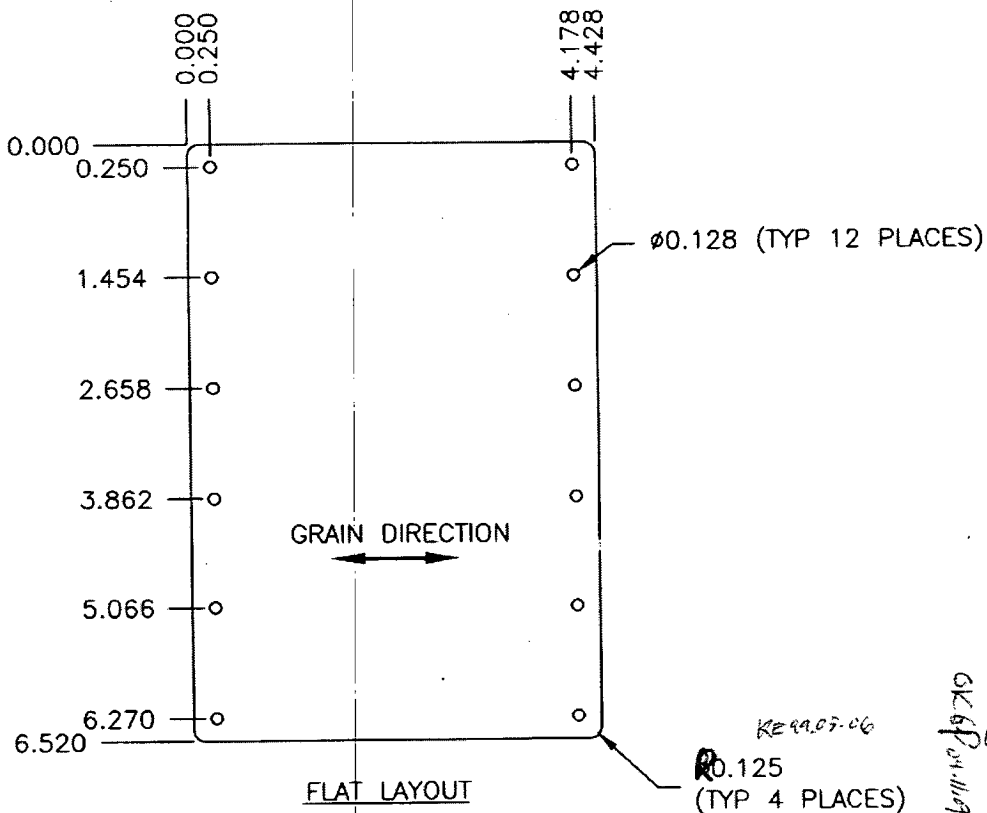
UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
JIS BEFORE MANUFACTURE

GK GP 01.11.09

KE 99.07.06



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 30813